

5/07

DART AEROSPACE LTD	Work Order:	22290
Description: Cam Lock Shaft	Part Number:	D3372-5
Dwg: D3372 Rev. A <i>page 6</i>	Qty:	<i>50 25 24</i>
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>AY</i>	05.01.25	<i>50 25</i>
2	MC	Turn as per Folio FA497 and Dwg D3372 Material: AISI 303 SS Round Bar Ø0.375 (M303R.375) Identify for D3372-5 Batch: <i>M16656</i>	<i>J.G</i>	05/10/27	25
3	QC2	Inspect parts as they come off the CNC machine	<i>J.G</i>	05/10/27	25
4	MV	Machine D3372-5 as per Folio FA497 and Dwg D3372 Identify as D3372-5	<i>En</i>	05/11/20	24 <i>pto</i>
5	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/12/18	24
6	QC8	Second check	<i>En</i>	05/11/18	24
7	MV	Deburr	<i>En</i>	05/11/18	24
8	QC5	Inspect work to Step 7	<i>En</i>	05/11/18	24
9	ST	Identify and Stock	<i>En</i>	05/11/21	24
10	AC	Cost / part	<i>J.G</i>	05-11-23	24
11	DC	Close W/O Inspect Level 21	<i>J.G</i>	05/11/23	04

Rev	Date	Change	Revised By	Approved
A	05.01.18	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 05.01.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.10.27		Update Dim. sheet E	<i>[Signature]</i>	05.11.22		<i>[Signature]</i> 05.11.22	<i>[Signature]</i> 05.11.23

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/11/18	4	one part scrap. wrong position in use.	<i>[Signature]</i> 05.11.22	Scrap, destroy No Replace.	<i>[Signature]</i> 05/11/18	<i>[Signature]</i> 05.11.23	<i>[Signature]</i> 05.11.23	<i>[Signature]</i> 05.11.23

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/11/23

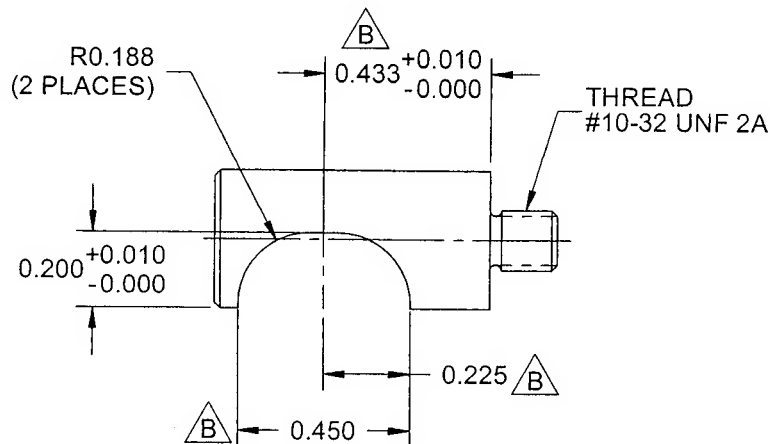
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28



D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 22290

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DART AEROSPACE LTD		Work Order:	22290
Description: Cam Lock Shaft		Part Number:	D3372-5
Inspection Dwg: D3372 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.390	+0.010/-0.000					
0.200	+0.010/-0.000					
R0.188	+/-0.010					
0.290	+0.010/-0.000					
0.563	+/-0.010					
0.170	+/-0.010					
0.365	+/-0.010	0.375	<input checked="" type="checkbox"/>			
14-20 Major dia	0.241 - 0.248					
MOV	0.252 - 0.259					
0.365	+0.010/-0.000	0.370	<input checked="" type="checkbox"/>			<div style="border: 1px solid black; padding: 5px; transform: rotate(-15deg); display: inline-block;"> 05.10.27 permanent change. </div>
0.900	±0.030	0.890	<input checked="" type="checkbox"/>			
0.175	±0.010	0.176	<input checked="" type="checkbox"/>			
R0.015 X 0.035	±0.010	0.015 X 0.035	<input checked="" type="checkbox"/>			
R0.015 X 0.035	±0.010	R0.015 X 0.035	<input checked="" type="checkbox"/>			
0.015 X 45°	±0.010	0.015 X 45°	<input checked="" type="checkbox"/>			
0.200	±0.010	0.200	<input checked="" type="checkbox"/>			
0.450	±0.010	0.448	<input checked="" type="checkbox"/>			can't measure (use d.m.c.r.)
0.200	±0.010/-0.000	0.200	<input checked="" type="checkbox"/>			
0.433	±0.010/-0.000	0.433	<input checked="" type="checkbox"/>			
R0.188	±0.010	0.188	<input checked="" type="checkbox"/>			
#10-32 UNF 2A	—	10-32 UNF 2A	<input checked="" type="checkbox"/>			

Measured by: S.G.	Audited by: En	Prototype Approval:	N/A
Date: 05/10/27	Date: 05/11/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.26	New Issue	KJ/JLM	

RELEASED

05/11/18

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

Work Order No : 0022290
Project Name : D3372-5
Project For : WK507
Work Order Type : Main
Main WO Number :
House Part Number : D3372-5
Description : Cam Lock Shaft
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00